

Date: Tuesday, 02/10/2007 12:59:25 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 34967					
Estimate Number	: 12884					
P.O. Number	: N/A		Part Number	: D3560044		
This Issue	: 02/10/2007 S.O. No. : N/A		Drawing Number	: D3560 UNDER REVIEW		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 34477		Material	: N/A		
Written By	:		Due Date	: 09/10/2007 Qty: 5 Um: Each		
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 07.05.24 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			<i>11 07.10.03</i>
2.0	D3560044	ARM WELDMENT	
			<i>11 07.10.03</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
	ARM WELDMENT	<i>332648</i>	<i>11 07.10.03</i>
3.0	D35921	PLATE	
			<i>11 07.10.03</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
	PLATE	<i>334260</i>	<i>11 07.10.03</i>
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			<i>11 07.10.03</i>
	Comment: LARGE FABRICATION RESOURCE 1		
	1-Weld assembly as per dwg D3560		<i>11 07.10.03</i>
5.0	QC5	INSPECT WORK TO CURRENT STEP	
			<i>11 07.10.04 (X5)</i>
	Comment: INSPECT WORK TO CURRENT STEP		
6.0	QC9	VISUAL WELDING INSPECTION	
			<i>11 07.10.04 (5)</i>
	Comment: VISUAL WELDING INSPECTION		

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Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WTR

5

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

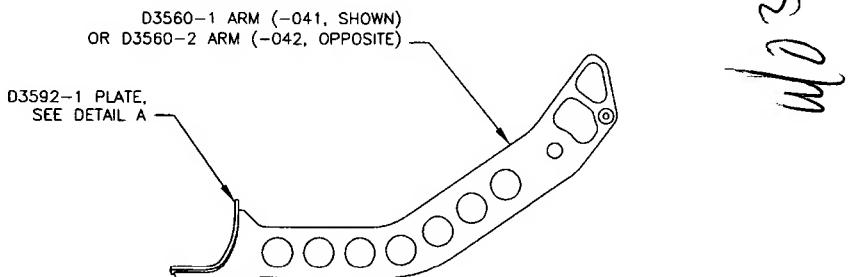
5

02/10/05

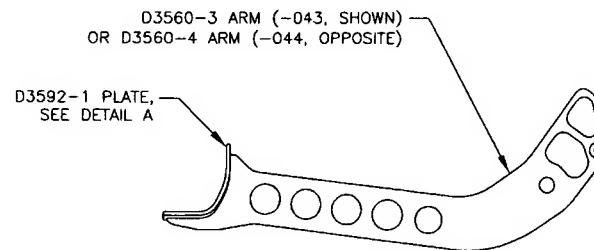
Job Completion



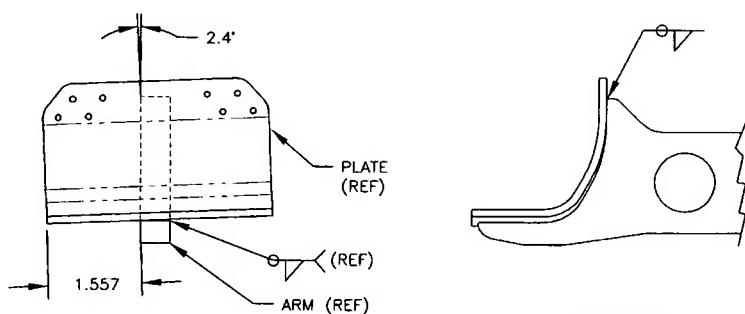
02/10/05



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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DESIGN	99	DRAWN BY	99	DART	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
CHECKED	<i>TT</i>	APPROVED	<i>TT</i>	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE	1:4
				REV. C	SHEET 1 OF 3

